

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006744**Date Inspected:** 08-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tu Jun and Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as East Tower Lift 2. The weld designations reviewed are as follows:

Bay 10

1. A/E Corner on the double diaphragm 53, 65 and 77m

Bay 11

SMAW welding of weld joint 44 and 29 located on PCMK WD1-A46-36M-2.

Welder is identified as Mrs. Xu Yiping (040655). ZPMC QC is identified as Mr. Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 25 located on ESD1-FDSA3-2C/G.

Welder is identified as Mr. Liu Jingyong (067500). ZPMC QC is identified as Mr. Zhang Zhi Neng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

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FCAW welding of weld joint 35 located on ESD1-FDSA3-2C/G.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Mr. Zhang Zhi Neng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

FCAW welding of weld joint 9 and 8 located on ESD1-FDSA3-2C/G.

Welder is identified as Mr. Nie Baofeng (066674). ZPMC QC is identified as Mr. Zhang Zhi Neng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

Bay 10

FCAW welding of weld joint 47 located on NSD1-FASA4-1A/E.

Welder is identified as Mr. Yu Yonglai (048378). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 46 located on NSD1-FASA4-1A/E.

Welder is identified as Mr. Tao Qian (040457). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

SAW welding of weld joint 6A located on NSD1-FASA4-1A/E.

Welder is identified as Mrs. Shen Xiaoquan (250522). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-2221-B-U3c-S-2.

SAW welding of weld joint 47A located on NSD1-FASA4-1E/E.

Welder is identified as Mr. Zhang Suqin (209051). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-2221-B-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for

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your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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